

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	204 STEP LUG
Job Number	:	34992			
Estimate Number	:	11843			
P.O. Number	:	N/A	Part Number	:	D23381
This Issue	:	10/3/2007 S.O. No. : N/A	Drawing Number	:	D2338 REV B
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	B
Previous Run	:	31209	Material	:	N/A
Written By	:	[Signature]	Due Date	:	10/20/2007 Qty: 10 Um: Each
Checked & Approved By	:	[Signature] 10.03			
Comment	:	Est. B 00.03.24 Separated -1 from -2 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.3827 f(s)/Unit Total : 3.0618 f(s)
6061-T6 Bar .50" x 6.0"
Material: 6061-T6 0.5 x 6.0"
Batch: M105145
1 blank makes one D2338-1 & one D2338-2

J.L 07/11/13

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut Blanks 8.75" long

J.L 07/11/13

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2338
Tumble & Deburr

S.F 07/11/14 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F 07/24/14 (10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BG 07.11.15 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 8/14/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:41:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 STEP LUG

Job Number: 34992

Part Number: D23381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WHA DTE*

PH 07-11-19

(10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

2011/11/19

Job Completion



u 07-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34992
Description: Endplate		Part Number: D2338-1
Inspection Dwg: D2338 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.975	+/-0.010	1.974	✓			
0.225	+/-0.010	.227	✓			
2.275	+/-0.010	2.477	✓			
3.475	+/-0.010	3.477	✓			
0.225	+/-0.010	.226	✓			
0.500	+/-0.010	.501	✓			
1.000	+/-0.010	1.002	✓			
3.425	+/-0.010	3.420	✓			
4.525	+/-0.010	3.533	✓			
5.025	+/-0.010	5.028	✓			
0.250	+/-0.010	.251	✓			
0.375	+/-0.010	.373	✓			
Ø0.257	+0.006/-0.001	.262	✓			
R0.500	+/-0.010	.500	✓			
R0.250	+/-0.010	.250	✓			

Measured by: J.F
Date: 07/11/14

Audited by: RP
Date: 07/11/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM	

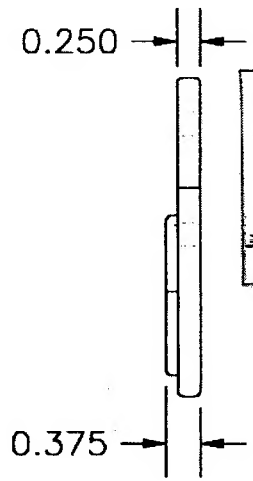


DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	<i>BWS</i>	APPROVED	<i>BWS</i>	DRAWING NO. D2338	SHEET 1 OF 1
DATE	95.01.25	TITLE	ENDPLATE	SCALE	1:2
B	96.03.29	RE-DESIGN AND ADD	D2338-2		

RELEASED
97/04/22 DS

UNDER REVIEW

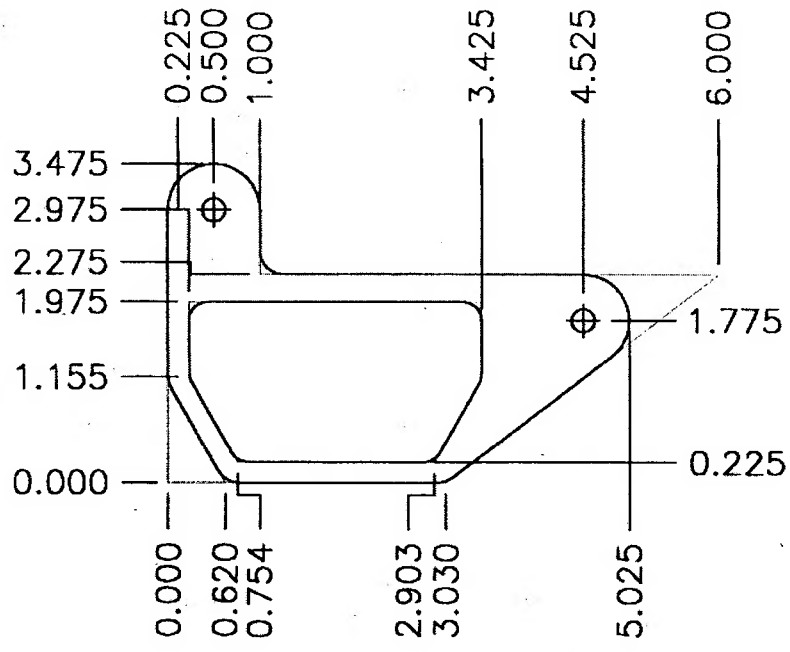
02.11.11



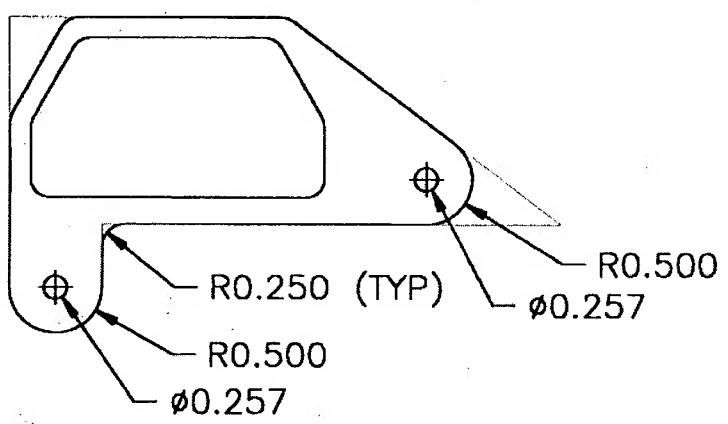
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

WORK ORDER NO. 34952
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE